



Dart Aerospace Ltd.
1270 Aberdeen St
Hawkesbury, ON
K6A 1K7
Canada

Tel (613) 632-5200
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U/R

6F9540V00131
Job Sheet 186754



Part No: 6F9540V00131

Job Qty: 1 ea

Concession Required

Part Name: AW169 Upper Cutter Deflector Assembly



Part Weight: 0 lbs

Status: New

Priority: Medium

Job Created: 11/21/18

Job Tracking No:

Due Date: 1/8/19

Created By: Marie Lajeunesse

Type: SOLD

Description:

Note: URF18-746 DWG REV C IPP REV:A 13.11.13 NEW ISSUE DD VERF:JLM

Ship Via:

Bill of Materials

Job Routing

Op No	Operation	Qty	Start Date	Due Date	Standard		Workcenter/Supplier		Sign-off
					Setup Hrs	Run Hrs	Workcenter / Supplier	Lead Time	
90	Start up Operation	1 Ea	1/8/19	1/8/19	0.00	0.00	Start Up Stores/Pkg-1		9-89 DAS 69 46
110	Packaging	1 pcs	1/8/19	1/8/19	0.00	0.00	Packaging1-1		9-89 DAS 69 46
120	QC	1 pcs	1/8/19	1/8/19	0.00	0.00	QC4		9-89 DAS 69 46
130	Packaging	1 pcs	1/8/19	1/8/19	0.00	0.00	Packaging3-1		9-89 DAS 69 46
135	DC	1 pcs	1/8/19	1/8/19	0.00	0.00	DC		9-89 DAS 69 46
140	QC21-FG	1 Ea	1/8/19	1/8/19	0.00	0.00	QC21		9-89 DAS 69 46

Part Op 130 - Identify and pack for shipping as per PPP 6F9540V00131

Descriptions: 135 - Photocopy bluefile per PPP D169-841-013 chg002 and create labels per 6F9540V00131 CHG002

Job BOM

Part / Item	Component Name	Quantity	Operation
D169-841-013	AW169 Upper Cutter Deflector	1 Ea (1 ea)	90-Start up Operation

Job Allocations

Operation	Component Part	Required	Inventory	Allocated
90-Start up Operation	D169-841-013	1	0	0

Part Specifications

Specifications could not be found.



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CANADA
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Plex 11/21/18 9:00 AM Dart.lajeunesse.marie

Container No: S147213



Part: 6F9540V00131

Job No: 186754

Serial No/Batch: S147213

Revision:

Inspector:

Exp Date:

Instructions:

Date: 01/23/19

DQA: _____ Date: _____



WORK ORDER NON-CONFORMANCE / UPDATE

QA Closed: _____ Date: _____

Work Order update only ☐

Work Order: _____ Part No. _____ NCR No. _____		DISPOSITION Rework ☐ Scrap ☐ Use-as-is ☐ Suspected Unapproved ☐		AGAINST DEPARTMENT/PROCESS Skid-tube ☐ Machining ☐ Thermoforming ☐ Large Fab ☐ Cross tube ☐ Small Fab ☐ Finishing ☐ Composite ☐ Water Jet ☐ Prod. Eng. Coord. ☐ Rec/Store/Packaging ☐ Supplier ☐ Engineering ☐ Quality ☐ Other ☐					
Date :		Step #:		QTY Effective :			MRB (QSI042) Approval		
Description Work Order Deviation				Disposition				Completed By	
								Lead hand / Supervisor Approval Verification	
								QC / QA Coordinator Approval	
Root Cause		FAULT CATEGORY							
Environment ☐	No Re-verification ☐	Pressure/Forced ☐	Temperature/Cure ☐	Power Loss/Surge ☐	Positioned Wrong ☐				
Design ☐	Operator ☐	Bending ☐	Set-up ☐	Folio/Program ☐	Outside Dimensions ☐				
Doc/Data ☐	Offset/Setup ☐	Centre Not Concentric ☐	BOM/Route ☐	Grain ☐	Over/Under tolerance ☐				
Equip/Tooling ☐	Supplier ☐	Cracks ☐	Broken/Damage/Defect ☐	Weld ☐	Part Incorrect ☐				
Handling/Pre ☐	Training ☐	Crimp/Kink/Ripple/Wave ☐	Inspection Incomplete/Unqualified ☐	Wrong Stock Pulled ☐	Part Lost/Missing ☐				
Material ☐	Use for Testing ☐	Cuffs ☐	Contamination ☐	Out of Sequence ☐	Part Moved ☐				
Internal Transport ☐	Poor Information ☐	Crushing ☐	Countersink ☐	Off-set ☐	Drawing ☐				
Tribal Knowledge ☐	Rushing ☐	Heat Treat ☐	Cut Too Short ☐	Mislabeled ☐	Finish ☐				
LOA ☐	Product Improvement ☐	Wave/Twist in Tube ☐	Instructions Incomplete/Unclear ☐	Fit/Function ☐	Misread ☐				
Substation ☐	Process Improvement ☐	Marks/Chatter ☐	Drill Holes ☐	Misaligned/off center ☐	Turning Sequence ☐				
Past Expiry Date ☐	Manufacturing Process ☐	OTHER : _____							
Misidentified ☐	Past Due ☐								

LEONARDO HELICOPTERS		Supplier Concession				PAGE 1 of 2	PLANT Vergiate	
Supplier NC N.	AWC-014/00		Date	28.01.2019		AW Concession	400000079572	
P/N	6F9540V00131		Grade/Category	NC		Purchase Order	4801861243	
Part Description	PROTECTR, CCP ASSY UPPER		Batch Quantity	3,000		Defective Quantity	3,000	
AW NC	MARCO FRANCESCONI		A/C Type/Model	AW6				
Supplier	DART AEROSPACE LTD		Contract					
Defect MA01 - Items or materials different from requir - S/N S147209, S147213, S147224 * 28.01.2019 17:33:38 MARCO FRANCESCONI (39978) * SEE SUPPLIER ATTACHED DOC. AWC-014 Cause of Defect								
				Repetitiveness (same P/N - Defect Code)		NO ☐ YES ☒		Follow (1)
ENGINEERING Evaluation and Proposal								
Engineering Evaluations, including Specialist inputs:			Investigation Report n.			Compliance Report n.		
* 04.02.2019 18:46:35 MARCELLO STEFANELLI (9273) * The deviation is acceptable, as for attached, it permits to install the part as for requirement								
Classification of Deviation from Type Design i.a.w. EASA Part 21A.91 : Minore/B								
Defect effect						Limitations		
	Before Repair		After Repair					
Safety	☐	YES	☐	YES ☐ NO	☐ YES (to specificity) ☒ NO			
Life or Duration	☐	YES	☐	YES ☐ NO				
Strenght	☐	YES	☐	YES ☐ NO				
Performances	☐	YES	☐	YES ☐ NO				
Interchangeability	☐	YES	☐	YES ☐ NO				
Reliability	☐	YES	☐	YES ☐ NO				
Maintainability	☐	YES	☐	YES ☐ NO				
Installability	☒	YES	☐	YES ☒ NO				
Testability	☐	YES	☐	YES ☐ NO				
Only Appearance	☐	YES	☐	YES ☐ NO				
No Effect	☐	YES	☐	YES ☐ NO				
Repair Proposal:					Decision			
* 04.02.2019 18:46:35 MARCELLO STEFANELLI (9273) * Drill on coordinate position during installation.					☐ Use rep. with spec.repair(not yet applied) ☒ Use repaired with known repair(yet applied) ☐ Use As Is ☐ Use repaired for tests only(see Limitations) ☐ Use As Is for tests only(see Limitations) ☐ Scrap			
Concession Classification		☐ MAJOR ☒ MINOR		Re-submit after Repair		☐ YES ☒ NO		
Mark part with Concession		☒ NO ☐ YES		Method :				
ATE	MARCELLO STEFANELLI		CPE			Date	04.02.2019	
Checks and tests to be performed								
Repair registration								
with repair WO		☒		Number:				
Repair Evaluation:								
Final Decision								
S/N	Use As Is (UTI)	Use Repaired (R/L)	Scrap (SCA)	S/N	Use As Is (UTI)	Use Repaired (R/L)	Scrap (SCA)	
S147209	☒	☐	☐		☐	☐	☐	
S147213	☒	☐	☐		☐	☐	☐	
S147224	☒	☐	☐		☐	☐	☐	
	☐	☐	☐		☐	☐	☐	
	☐	☐	☐		☐	☐	☐	
	☐	☐	☐		☐	☐	☐	
	☐	☐	☐		☐	☐	☐	
	☐	☐	☐		☐	☐	☐	
	☐	☐	☐		☐	☐	☐	
	☐	☐	☐		☐	☐	☐	
Not Serialized	Use As Is (Q.ty)	3,000	Use Repaired (Q.ty)		Scrap (Q.ty)			
Role	AW ATE	AW CPE	Inspection Clearance Repair	Quality	Customer	MoD or Authority Representative		
Signature	MARCELLO STEFANELLI							
Date	04.02.2019							

Supplier NC N.	AWC-014/00	Date	28.01.2019	AW	400000079572	Purchase Order	4801861243
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DEFECT 0001 **MA01** *Items or materials different from requir*
 S/N S147209, S147213, S147224

*

DEFECT CAUSES

* C41 Material did not comply with specificati

<i>Manuf. Doc. N.</i>	AWC-014	<i>Date</i>	Jan 25, 2019	<i>AW Doc. N.</i>	400000079572	<i>Purchase Order</i>	4801861243
<i>AW P/N</i>	6F9540V00131	<i>S/N / Batch Number</i>	SI47224 SI47209 SI47213	<i>Grade</i>	A	<i>AW Drawing Issue</i>	B
<i>Description</i>	Protector, CCP Lower Assembly			<i>Batch Q.ty</i>	3	<i>Defective Q.ty</i>	3
<i>Manufacturer</i>	Dart Aerospace LTD			<i>Model</i>	AW169		

Defect(s) Description

**D4857-041 (x2) , P/N 6F9540V0131, to be supplied with out the 4x Ø5.33mm / Ø.210" holes drilled per drawing but with the 4x Ø5.33mm / Ø.210" in the D4944-1 gasket
The operation of drilling the 4x Ø5.33mm / Ø.210" holes to be performed by Leonardo operators on attached production permit..**

<i>Department</i>	<i>Inspector</i>	<i>Signature</i>	<i>Date</i>
Quality Assurance	DAS-16-9-89	P. Duval	Jan 25, 2019

Defect(s) Cause

**Due to issue regarding from QJ 200001282441 Dart Aerospace Drawing requirements and requirements specified in Leonardo's 3d model parts are to be supplied to Leonardo with out the Ø5.33mm / Ø.210" holes drilled per drawing D4857-041 (-1).
Previous parts provided the hole pattern do not match the H/C structure**

<i>Department</i>	<i>Inspector</i>	<i>Signature</i>	<i>Date</i>
Quality Assurance	DAS-16-9-89	P. Duval	Jan 25, 2019

Corrective Action

Complete Before

Dart Aerospace HBY requesting drawing update to allow hole location in D4857-041

<i>Department</i>	<i>Inspector</i>	<i>Signature</i>	<i>Date</i>
Quality Assurance	DAS-16-9-89	P. Duval	Jan 25, 2019

For "MANUFACTURER" SUPPLIERS ONLY
ENGINEERING evaluation and proposal

Engineering evaluation

Investigation report

n: NCR17-6591

Compliance report

n... N/A.....

Dart Aerospace HBY requesting drawing update to allow hole location in D4857-041

Defect effects			Limitations
	Before any repair	After any repair	
	☐ yes	☐ yes ☐ no	☐ yes (specify) ☒ no
Safety	☐ yes	☐ yes ☐ no	
Life	☐ yes	☐ yes ☐ no	
Strength	☐ yes	☐ yes ☐ no	
Performances	☐ yes	☐ yes ☐ no	
Interchangeability	☐ yes	☐ yes ☐ no	
Reliability	☐ yes	☐ yes ☐ no	
Maintainability	☐ yes	☐ yes ☐ no	
Installability	☐ yes	☐ yes ☐ no	
Testability	☐ yes	☐ yes ☐ no	
Only aspect	☐ yes	☐ yes ☐ no	
Repair Proposal			Decision to use ☐ Use repaired with specific repair ☐ Use repaired with known repair ☐ Use as is ☐ Use repaired for tests (see Limitations) ☐ Use as is for tests (see Limitations) ☐ Scrap
Concession Classification	☒ Major ☐ Minor	Submit after repair	☐ yes ☐ no